

Work Order ID 128329

128329

Page 1

January-15-15 2:07:36 PM

Item ID: D350-616-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Full Emergency Litter

Start Date: 1/15/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-616	G

100	Document Control	0.00	<u>Sup</u> <u>habel</u>					MW	150129
100	DC	0.00							
Doc.Control -USB or Paperwork									
Memo									
Photocopy bluefile and create labels per PPP D350-616-011									
CHG006									

JAN 29 2015

~~DAS~~
~~08~~
~~9-00~~

101		0.00							
101	Small Fab	0.00							
Small Fab									
Memo									
1- Assemble as per Dwg D2370									
2- Transfer drill using D4812-041 as template and open to size 0.257" as per Dwg D2370 AND DT9935 DRILL JIG									
3- Ensure fit of D4812-041 and remove for shipping									
D4812-041 MUST STAY WITH LITTER FRAME									
4- Deburr									

JAN 22 2015

~~DAS~~
~~28~~
~~9-00~~

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[illegible]

Work Order ID 128329

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January-15-15 2:07:36 PM

Item ID: D350-616-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Full Emergency Litter

Start Date: 1/15/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/15

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-616-011

Location: 031

PPP Rev: _____

JAN 29 2015

DAS
06
3:09

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5 1501-29

15.1-29

Picklist Print

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Work Order ID: 128329

128329

Parent Item: D350-616-011

D350-616-011

Parent Item Name: Full Emergency Litter

Start Date: 1/15/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP E03.04.04ReformatKJ/RF
IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G
13.05.21 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1 *D2370-1* Litter Frame Assembly		Manufactured	No		127491		Each	0.0000	**	1 FF		JAN 22 2015	DAS 28 9-89
D350-616-013 *D350-616-013* Deck Plate & Tie Down		Manufactured	No				Each	0.0000	**	125118			DAS 28 9-89
D4812-041 *D4812-041* Patient Stop Assembly		Manufactured	No				Each	7.0000	**	FF		JAN 22 2015	

Location

Loc Qty

Loc Code

ST371

7

124394

1

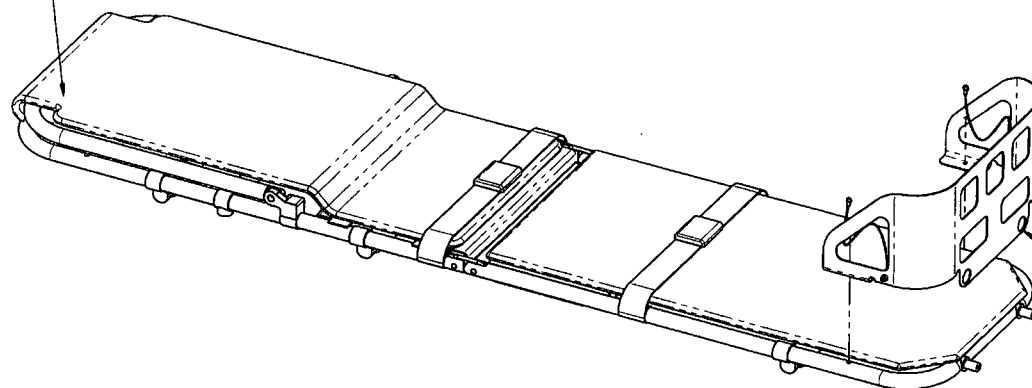
126501

6

DAS
28
9-89

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

D2370-1 LITTER FRAME ASSEMBLY



D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

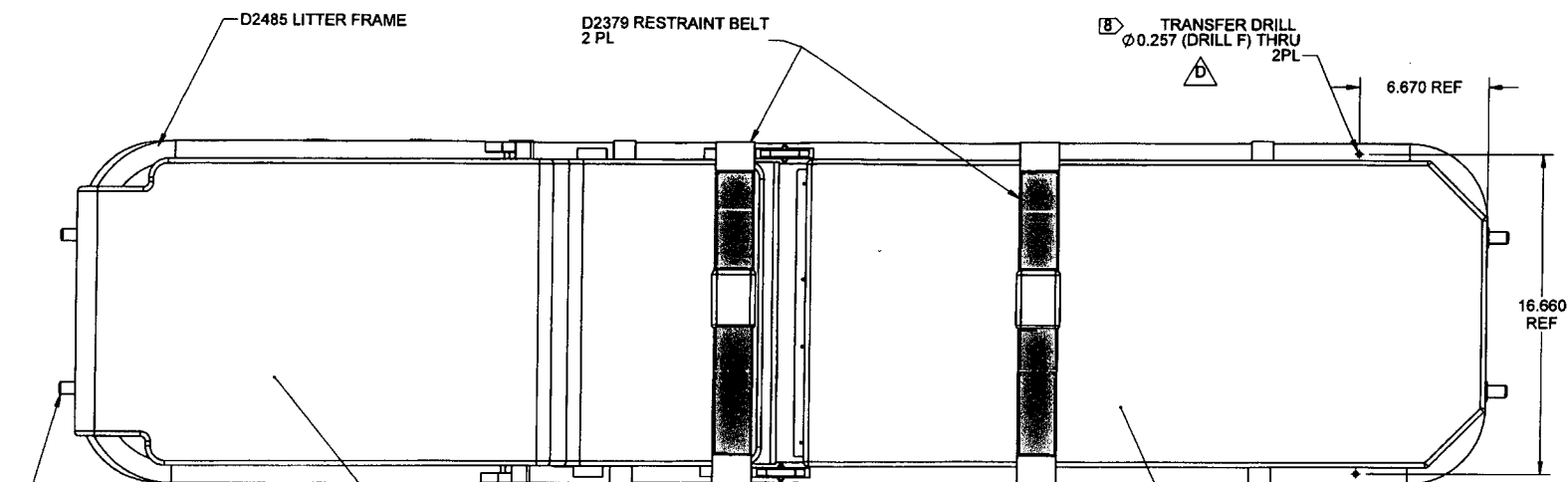
RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2370 REV. D TITLE LITTER ASSEMBLY SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	13.03.27		

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QSI 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2370 TITLE LITTER ASSEMBLY COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
DRAWN	DB	
CHECKED	A.P.	
MFG. APPR.		
APPROVED		
DE APPR.		REV. D
DATE	13.03.27	SHEET 2 OF 2
		SCALE NTS